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005118

D350-589-011
Job Sheet 182068



Part No: D350-589-011

Job Qty: 5 ea

Part Name: Side Door Latch Modification



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/16/18

Job Tracking No:

Due Date: 9/8/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG INN-D350-589 REV E, DSI9760-013 IPP F 02.08.29 Removed D2587 Plug KJ ALL AT CHANGE 002

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	5 Ea	9/8/18	9/8/18	0.00	0.00	Start Up Stores/Pkg-2		
105	Packaging	5 pcs	9/8/18	9/8/18	0.00	0.00	Packaging1-3		
110	QC	5 pcs	9/8/18	9/8/18	0.00	0.00	QC4		
120	Packaging	5 pcs	9/8/18	9/8/18	0.00	0.00	Packaging3-1		
125	DC	5 pcs	9/8/18	9/8/18	0.00	0.00	DC		
130	QC21-FG	5 Ea	9/8/18	9/8/18	0.00	0.00	QC21		

AUG-22-2018
Sign-off

SEP 13 2018

SEP 13 2018

SEP 14 2018

SEP 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2237	Striker Plate	15 Ea (3 ea)	90-Start up Operation	3051680X14
D2583	Latch Bracket	15 Ea (3 ea)	90-Start up Operation	5056268
D2585	Latch Clamp	15 Ea (3 ea)	90-Start up Operation	5054609
D2586	Door Latch	15 Ea (3 ea)	90-Start up Operation	5057725X4 5104316X11
D2587	Door Plug	5 Ea (1 ea)	90-Start up Operation	5038352
D2589	Keys, Key Chain	5 Ea (1 ea)	90-Start up Operation	5132942
MS20470AD4-5	Rivet, Universal Head	30 Ea (6 ea)	90-Start up Operation	5049829
MS21042L3	Nut	15 Ea (3 ea)	90-Start up Operation	5089340
MS27039-1-15	Screw	15 Ea (3 ea)	90-Start up Operation	5038766
NAS1149D0363J	Washer	15 Ea (3 ea)	90-Start up Operation	5068661

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2237	15	34	0
	D2583	15	37	0
	D2585	15	36	0
	D2586	15	19	0
	D2587	5	20	0
	D2589	5	223	0
	MS20470AD4-5	30	2,165	0
	MS21042L3	15	3,994	0
	MS27039-1-15	15	174	0
	NAS1149D0363J	15	1,847	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ ☐ Work Order update only

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Large Fab ☐	Compos ☐			

Date : _____	Step #: _____	QTY Effective : _____	QSI042) Approval
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Description Work Order Deviation	Dispos

Container No: S104481
Part: D350 - 589 - 011
Job No: 182068
Serial No/Batch: S104481
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH92-41 Issue Ref: FAAS TC SH1012N

DART AEROSPACE

Completed By _____

hand / Supervisor roval Verification

QA Coordinator Approval

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Root Cause				FAULT CATEG			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Weld	☐ Part Incorrect	☐ sitioned Wrong	☐
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ itside Dimensions	☐
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Out of Sequence	☐ Part Moved	☐ /er/Under tolerance	☐
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Off-set	☐ Drawing	☐	☐
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Mislabeled	☐ Finish	☐	☐
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Fit/Function	☐ Misread	☐	☐
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Turning Sequence	☐	☐
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes				
Past Expiry Date ☐	☐ Manufacturing Process						
Misidentified ☐	☐ Past Due	☐ OTHER :					

Part Specifications

Specifications could not be found.

Plex 8/16/18 3:00 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS				
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						
OTHER : _____								

3.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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Revision: E

Date: 02.02.22

Change Record

PAGE 1 OF 1

Part Number: D350-589-011

Description: SIDE DOOR LATCH MODIFICATION INSTALLATION

[illegible]